

ABSTRACT

The present invention provides a method for manufacturing a right-and-left screw having an external right-handed thread and an external left-handed thread which meet
5 an effective diameter of a specification by an inexpensive rolling process.

When a first external thread and a second external thread is simultaneously shaped by rolling a screw material using a rolling die having a first thread cutting blade for said first external thread and a second thread cutting blade for said second external thread
10 on the same surface, a diameter of the screw material is smaller than that of the screw material generally using only for the first external thread.